

Work Order ID 76764***76764***

Page 1

Monday, November 21, 2011 10:32:22 AM

Item ID: D2661-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-11-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1


Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB071

FOLIO REV: AA

DWG REV: 

SL 11-12-12



110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-12-12

8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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NS1

Revision ID:

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Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

*11-12-12****120***

QC

Memo

0.00

Quality Control

*8**0*

130

QC8- Inspect parts - second check

0.00

*11/12/12****130***

QC

Memo

0.00

Quality Control

*8**0*

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8xpm 11/12/13

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Item Name: Saddle, RH Fwd Aft Out 206
Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 8:15	0.00							
	FINISH TIME: 8:45								
160	QC3- Inspect Part Finish	0.00							
160									
QC									
Quality Control	Memo								
170	Identify as per dwg & Stock Location: 4/30	0.00							
170									
Packaging	Memo								
Packaging									

W119480

3200F

8X0 M-11/12/14

8 BL 11-12-14

11/12/14 (8)

W/O:		WORK ORDER CHANGES					
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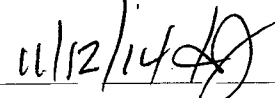
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Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/14 

11-12-14
(8)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 10:32:26 AM

Page 1

Work Order ID: 76764

76764

Parent Item: D2661-2

D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			

D6101-003

Saddle Billet, 7075

**

11-12-11

Location	Loc Qty	Loc Code
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	8
MAT44	29	
72226	2	
73769	1	
74680	26	

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DART AEROSPACE LTD	Work Order: 74764
Description: 206 Saddle, Outboard, Right side	Part Number: D2661-2
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.124	.124		
B	0.100	0.140		.120	.119	.120	.120		
C	1.125	1.145		1.135	1.135	1.134	1.135		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.248	.249	.248	.248		
F	1.313	1.343		1.322	1.323	1.323	1.323		
G	0.210	0.230		.219	.220	.220	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.576	1.575	1.576		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		5.999	5.999	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.798	.797	.797	.797		
W	0.540	0.560		.549	.549	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.920	.920	.921	.921		
AA	0.490	0.510		.501	.500	.500	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J
Date:	11-12-11

Audited by:	cmf
Date:	11/12/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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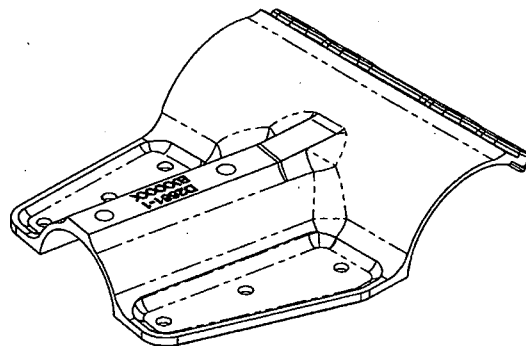
DART AEROSPACE LTD	Work Order:	7117124
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

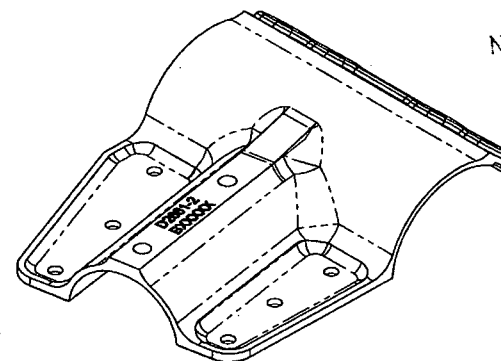
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L	0.100	0.120		.111	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
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AA	0.490	0.510		.499	.499	.499	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u> JL </u>	Audited by: <u> m </u>
Date: <u> 12-12-12 </u>	Date: <u> 11/12/12 </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.10.13	Dimensions C and F revised	KJ	<u> NA </u>



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70-764

11/11-21

RELEASED
2011-11-16
[Signature]

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 8122, 8102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2661	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

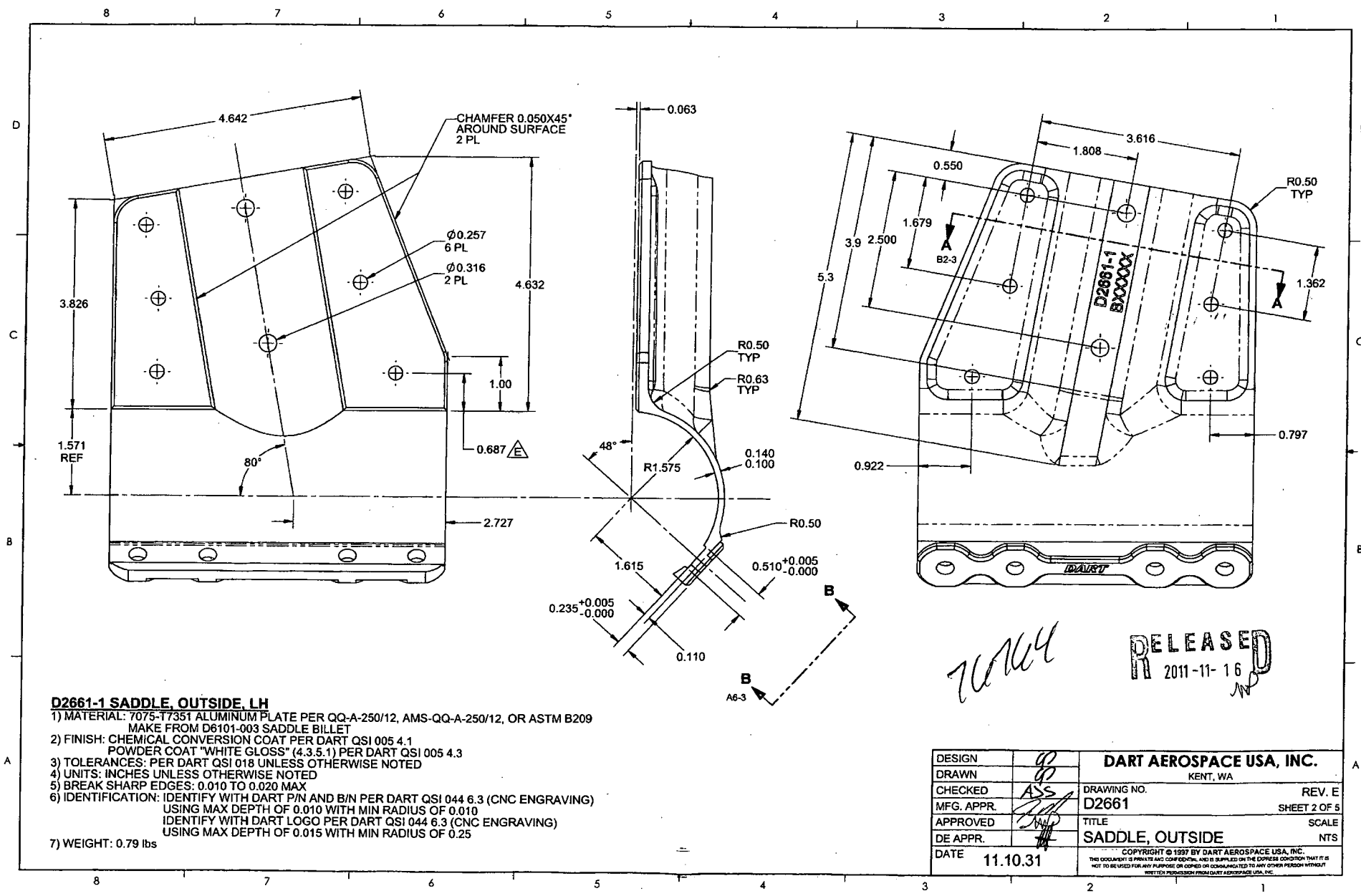
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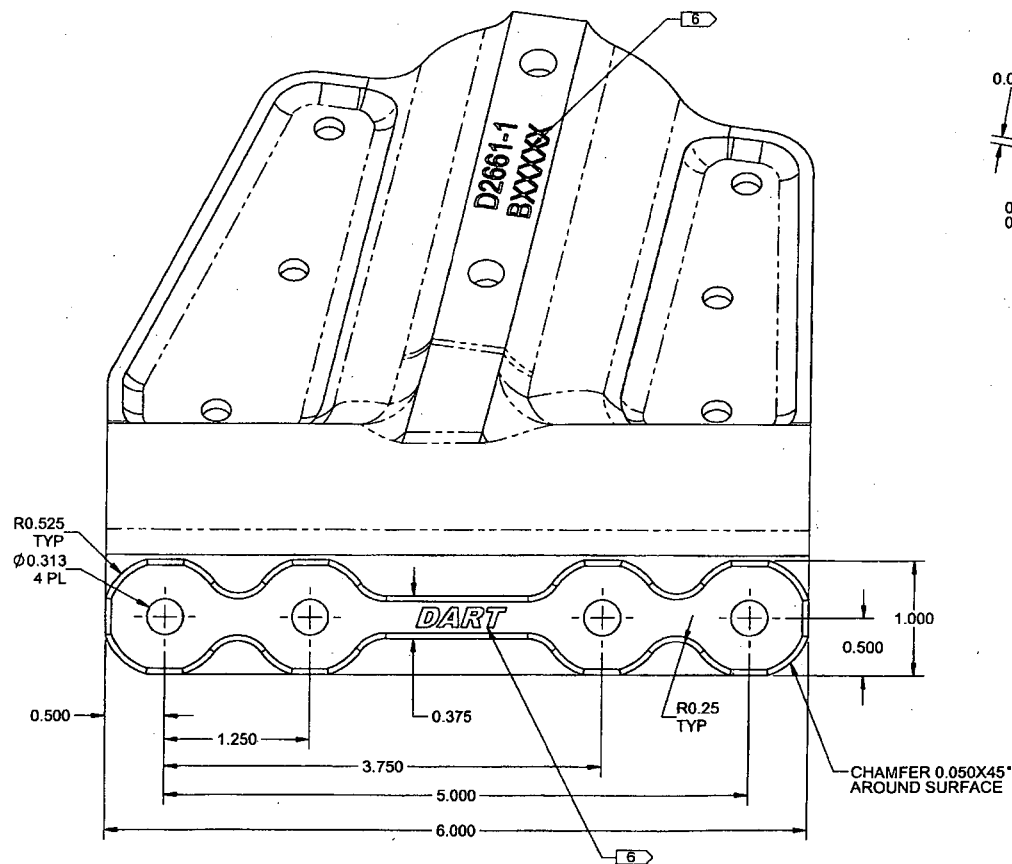
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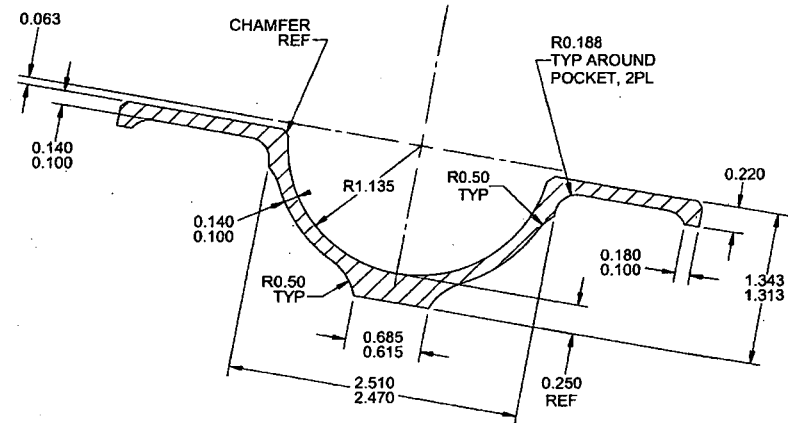
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NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

Handwritten signature

RELEASED
R 2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

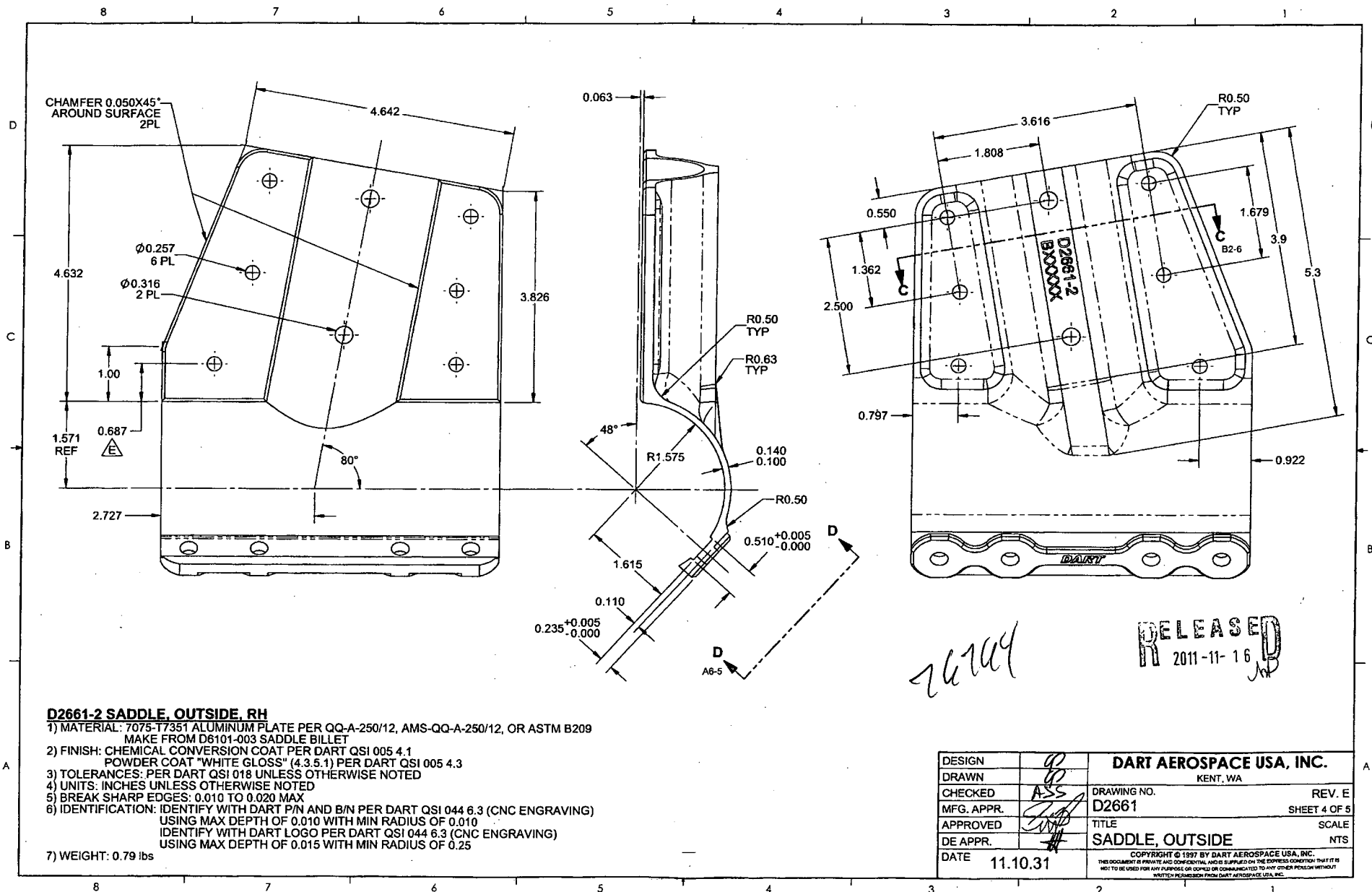
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D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN	98	DART AEROSPACE USA, INC.	
DRAWN	ASS	KENT, WA	
CHECKED	304	DRAWING NO.	REV. E
MFG. APPR.	304	D2661	SHEET 4 OF 5
APPROVED	304	TITLE	SCALE
DE APPR.	304	SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

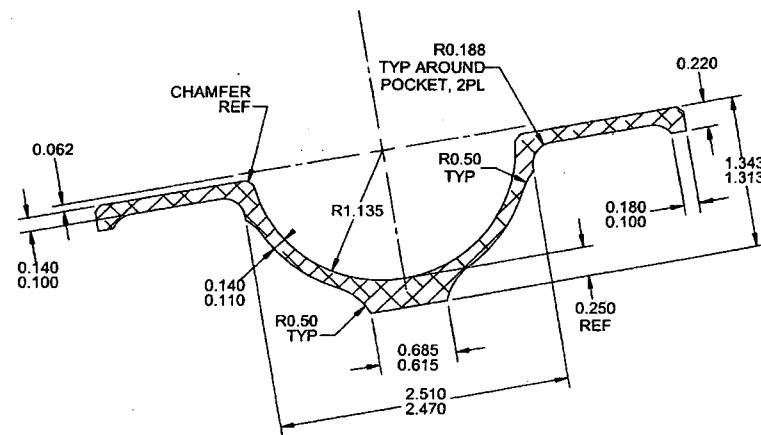
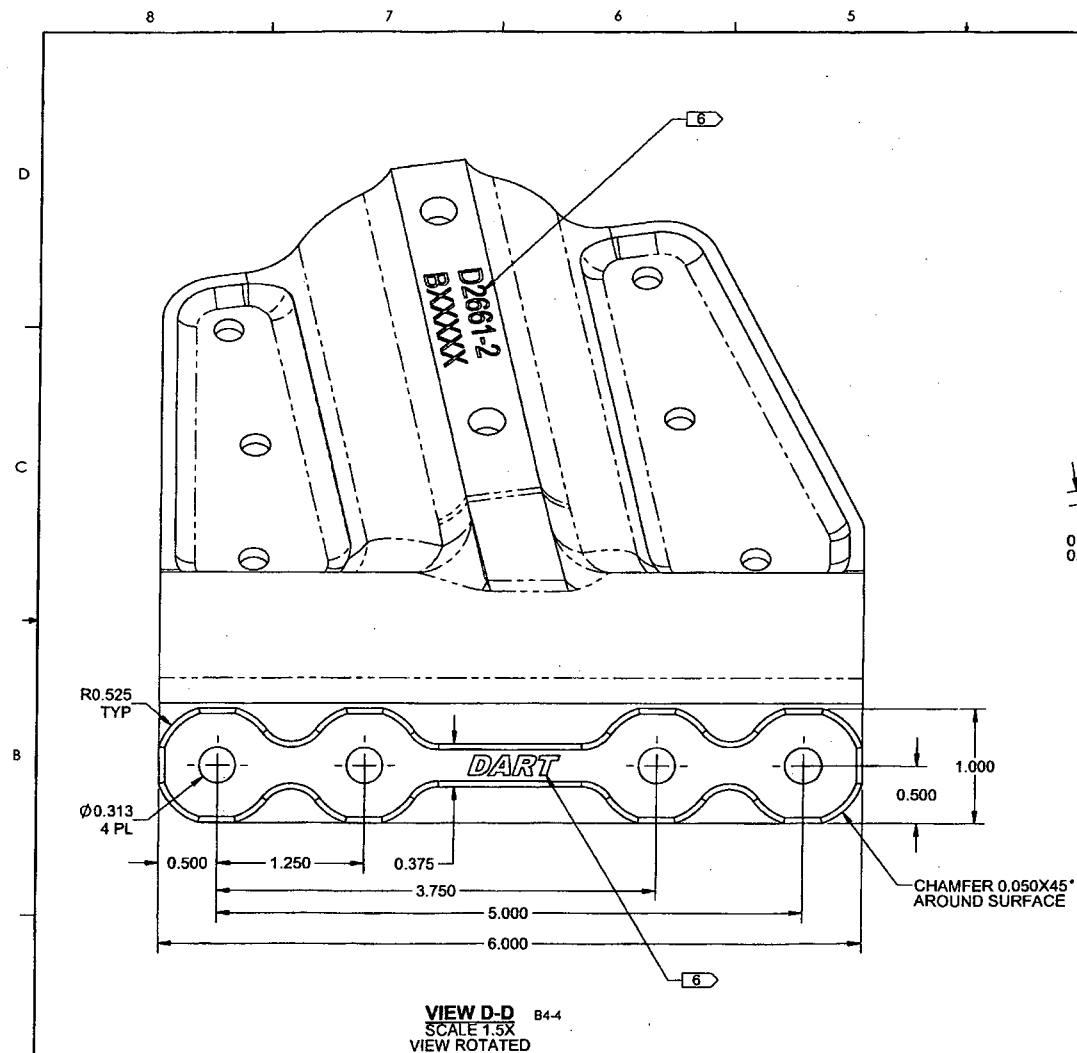
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76764

RELEASED
2011-11-16

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DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SCALE	NTS
DE APPR.		SADDLE, OUTSIDE	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries